

Date: Thursday, 02/04/2009 2:28:35 PM.
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL-350 UPPER BULKHEAD
Job Number : 46879	
Estimate Number : 13100	
P.O. Number :	Part Number : D36553
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3655 UNDER REVIEW <i>DL 09/04/08</i>
Prsht Rev. : NC	Project Number : 00204
First Issue : // Type : THERMOFORMING	Drawing Revision : B
Previous Run : 39709	Material :
Written By :	Due Date : 09/04/2009 Qty: 1 Um: Each
Checked & Approved By : <i>JUD 09.04.03</i>	
Comment : Est. Rev. A 07/12/13 New Issue DL verified by:DD Est. Rev. B 08/09/25 Dwg. Update DL.	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET



Comment: Qty.: 34.6600 sf(s)/Unit Total: 34.6600 sf(s)
 GE PLASTICS LEXAN SHEET
 batch: *M107574*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 09/04/07 X2

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3655-3and Folio FTA 017 using tool DT 8985

Dwg. Rev. *B*
 Folio Rev. *A*

BB 09/04/08 X2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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P.T.O.


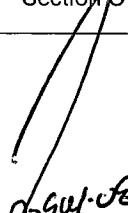

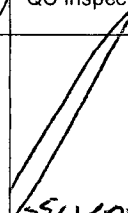
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/08 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3655-3 PAR #: N/A Fault Category: Prod Thermforming NCR: (Yes) No DQA: D Date: 05/04/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46879</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/08	3.0	SHEET TO HIGH MOISTURE CONTENT RC: process.		DRIED OVERNIGHT + lower TEMP. Investigate into a pre-heat dry process scrap & destroy Qty 1 part.	BB 04/09/08			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:28:35 PM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 UPPER BULKHEAD

Job Number: 46879

Part Number: D36553

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Sorvelos



Comment: SECOND CHECK

BB 09/04/08 (X1)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3655

BB 09/04/08 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/08 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08 (X1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

BB 09/04/08 (X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BB 09/04/08 (X1)

Job Completion



MF 09-04-08

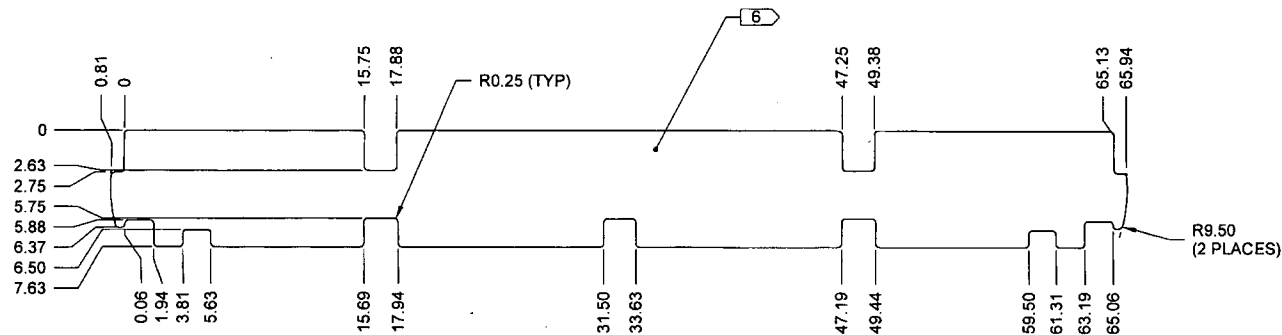
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3655-1 PANEL

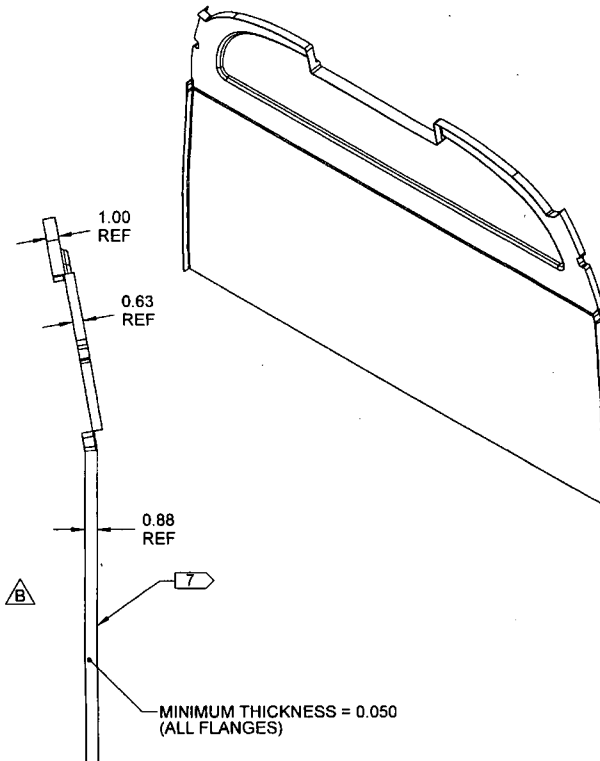
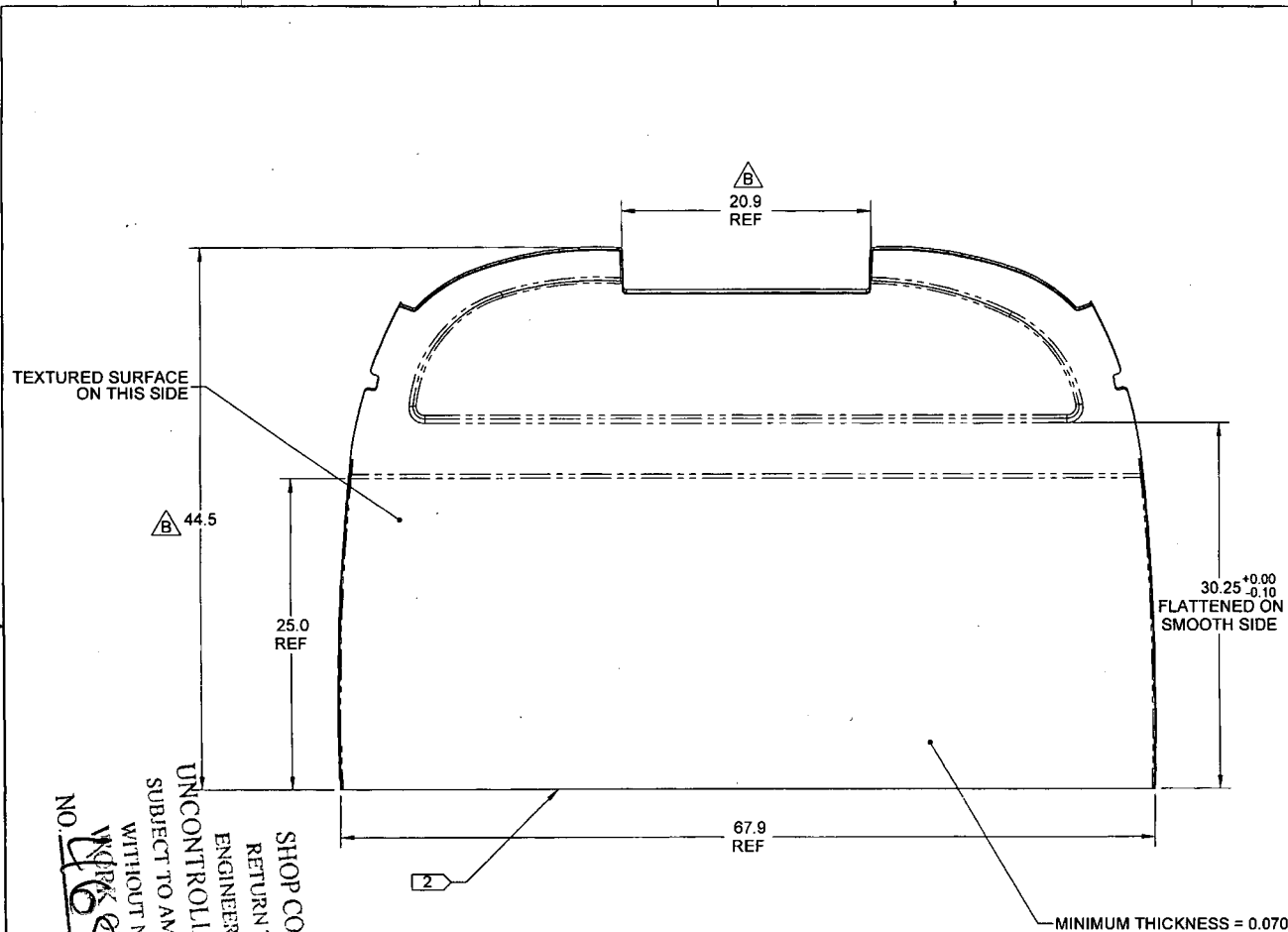
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08-09-30/17

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WITHOUT NOTICE

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	08.06.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3655 REV. B SHEET 1 OF 2 TITLE PANEL SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			



D3655-3 PANEL

RELEASED
08-09-30-18

D3655-3 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022
TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 10.8 lbs

DESIGN	CE	DART AEROSPACE LTD	
DRAWN	1/24	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.06.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NO. 108679
WORK ORDER
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DART AEROSPACE LTD	Work Order: 46879
Description: 350 Upper BulkHEAD	Part Number: D3655-3
Inspection Dwg: D3655 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9		67.9	✓			
44.5		44.475	✓			
30.25		30.25	✓			
.050	M.I.D	.055	✓			
.070	M.I.D	.085	✓			

Measured by: BB

Date: 09/04/08

Audited by: S

Date: 09/04/08

Prototype Approval: u/a

Date: u/a

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	